

Date: Wednesday, 6/27/2007 3:26:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING	
Job Number : 33240		
Estimate Number : 11870		
P.O. Number : <i>N/A</i>	Part Number : D22071	
This Issue : 6/27/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2207 REV C <i>PRELIM</i>	
Prsht Rev. : NC	Project Number : <i>N/A</i>	
First Issue : <i>N/A</i>	Drawing Revision : C <i>PRELIM</i>	
Previous Run : <i>N/A</i>	Material : <i>N/A</i>	
Written By : <i>[Signature]</i>	Due Date : 7/4/2007	Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.06.28		
Comment : Est. A 01.03.08 New Issue		

Additional Product

POSITIVE RECALL

EFFECTIVE *07.06.28* AUTH *[Signature]*RELEASED *07.06.28* DATE *[Signature]*

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch *M100285**IB 07-06-28*

2.0	SHEAR	SHEAR
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Comment: SHEAR

Shear blanks: 4.200" x 14.00" +.000"/-.030"

Grain along 14.00"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA031

Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE


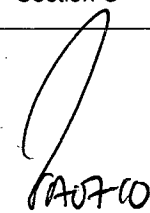
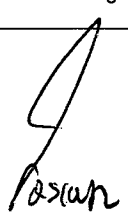
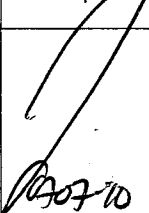
5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/09	6	1 piece was out of tolerance	 07/02/09	Scrap & destroy	SB 07/02/09	 07/02/09	 07/02/09	 07/02/09

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 3:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 33240

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SB 07/07/09 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/10 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 07/07/10 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

SB 07/07/10

Job Completion



POSITIVE RECALL

EFFECTIVE

1/1/10

AUTH 1/1/10

RELEASED

1/1/10

DATE 07-07-10

u 07-07-10

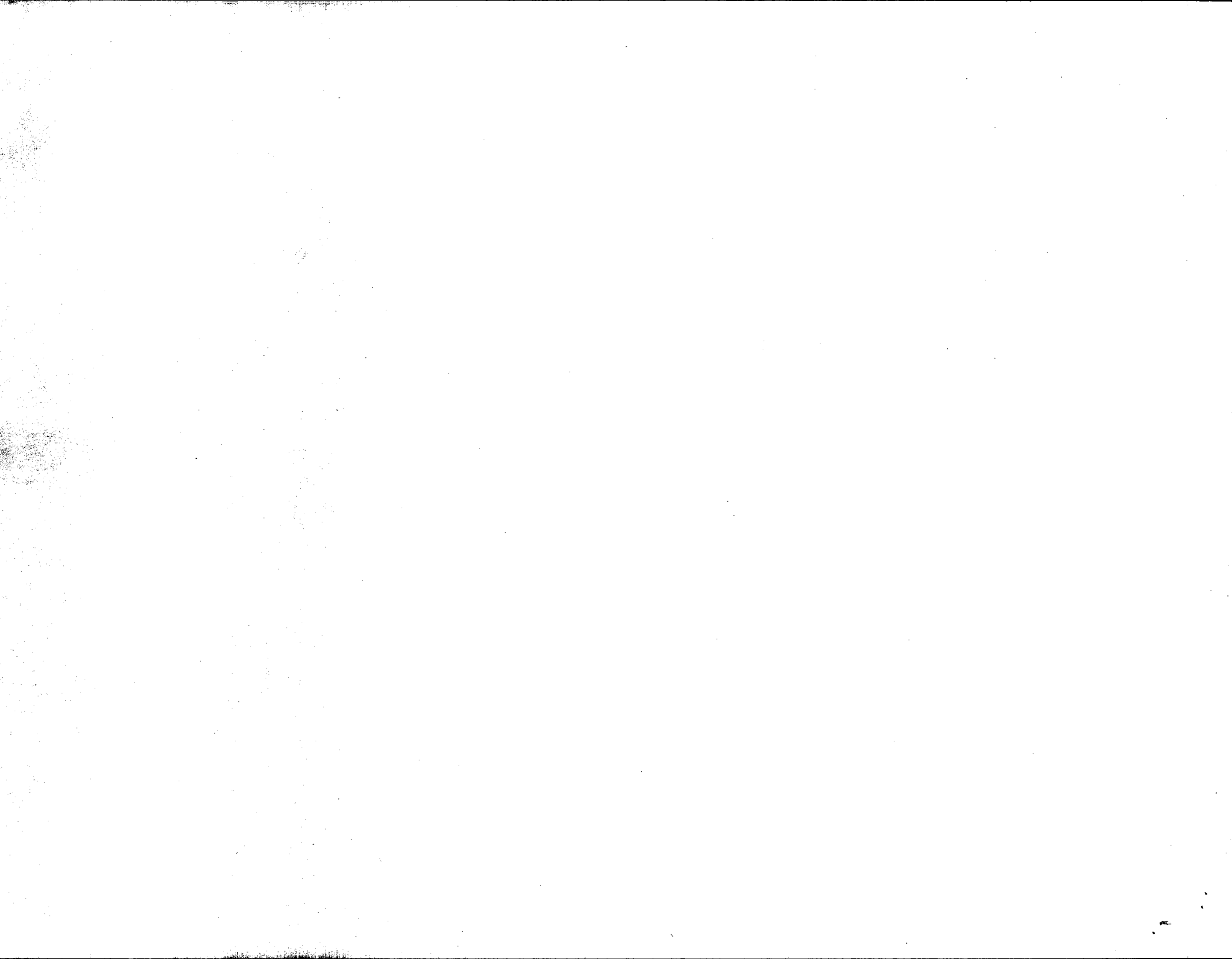
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

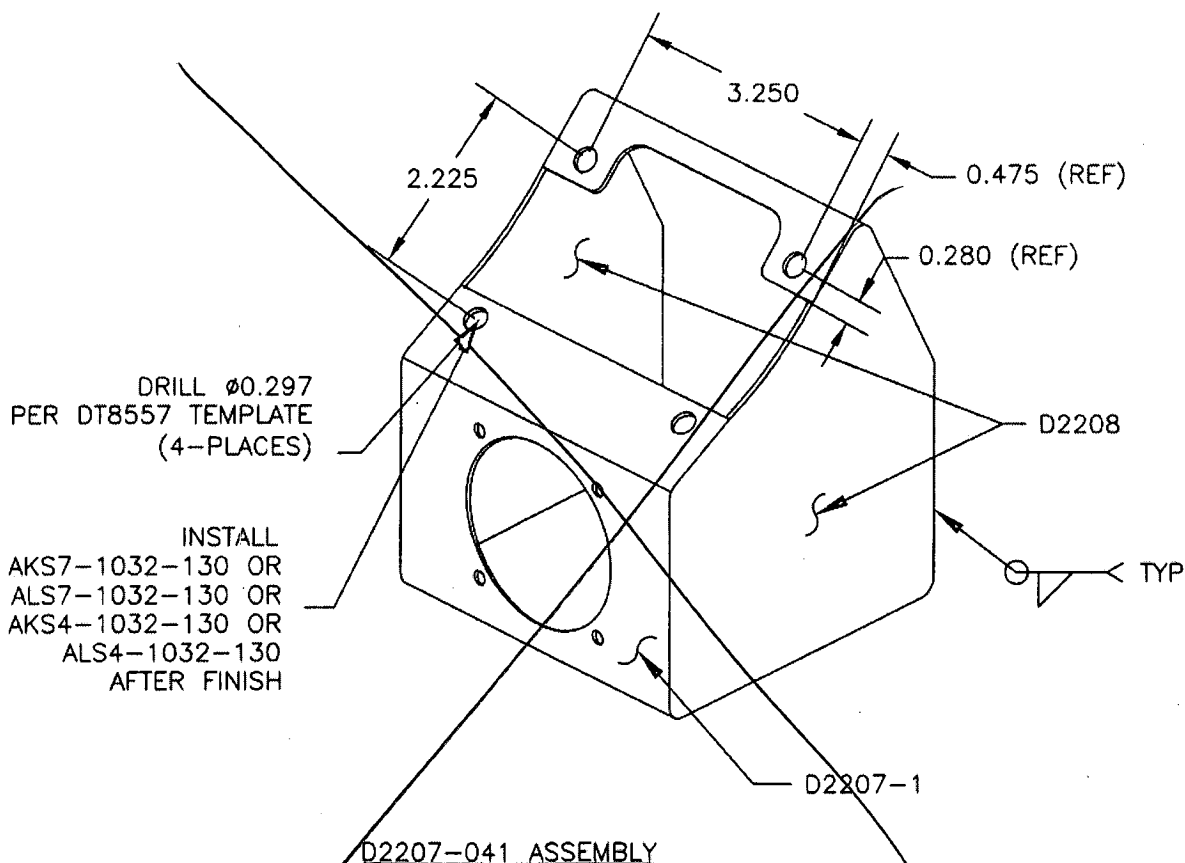
NOTE: Date & initial all entries





DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23		TITLE HOUSING	SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

RELEASED
01.02.27 #



NOTE:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 33240

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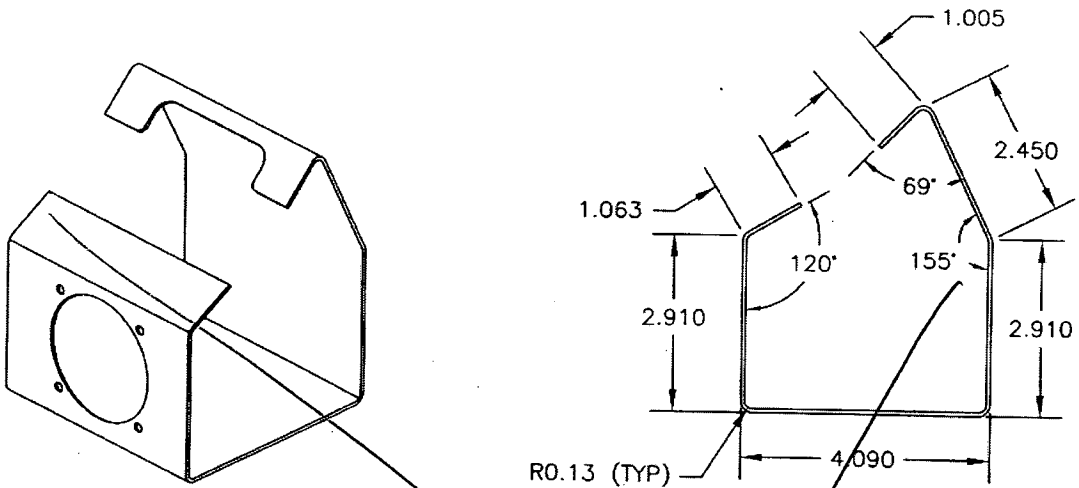
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DART

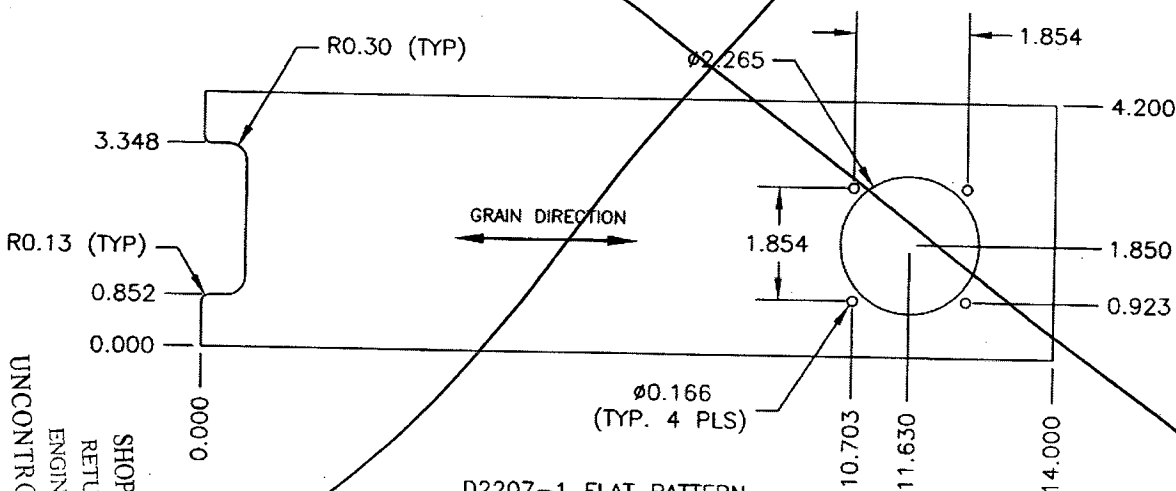


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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2207
DATE	01.02.23	TITLE	HOUSING	REV. B	SHEET 2 OF 2
				SCALE	1:3

RELEASED
01.02.27



D2207-1 BENDING DETAIL

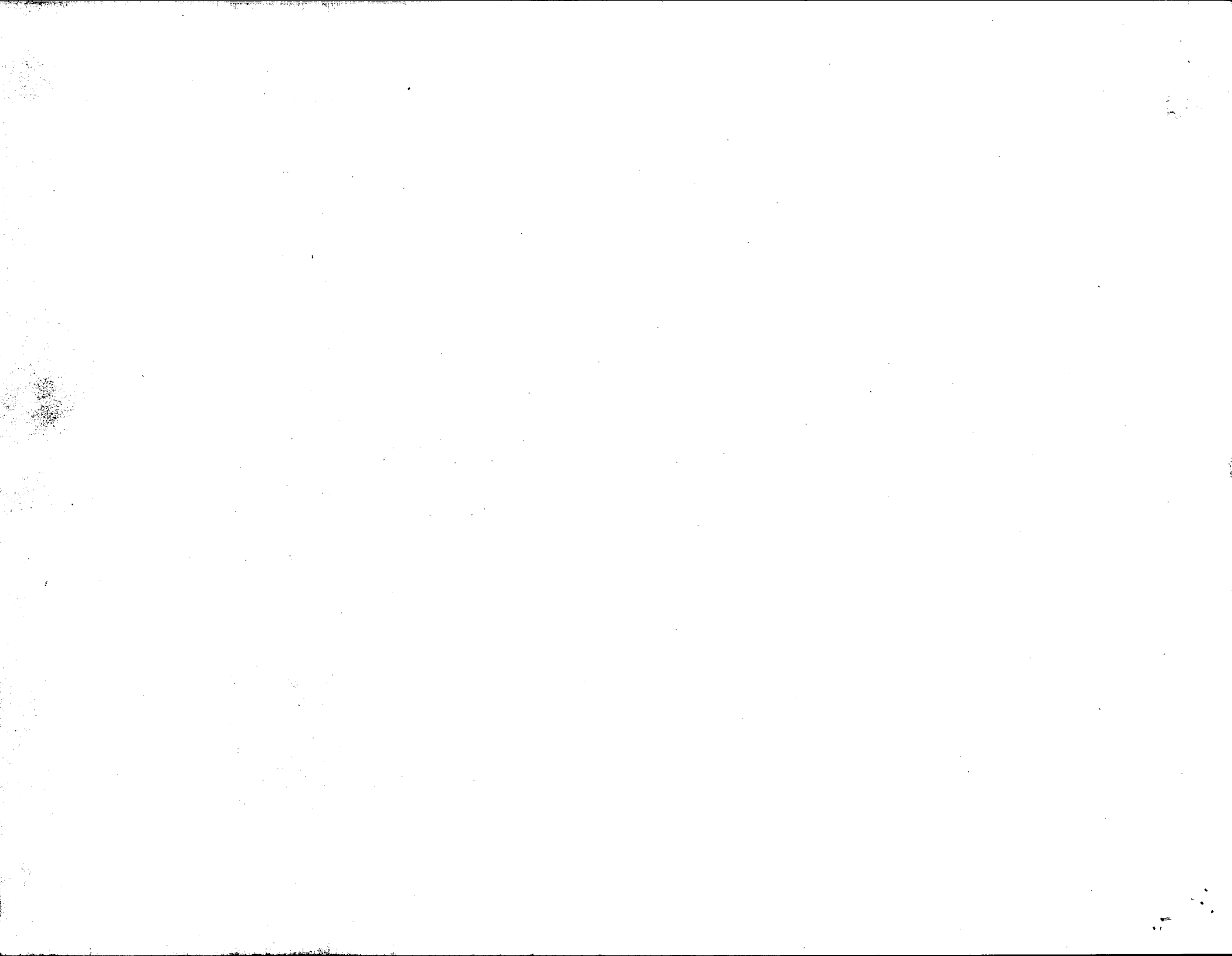


D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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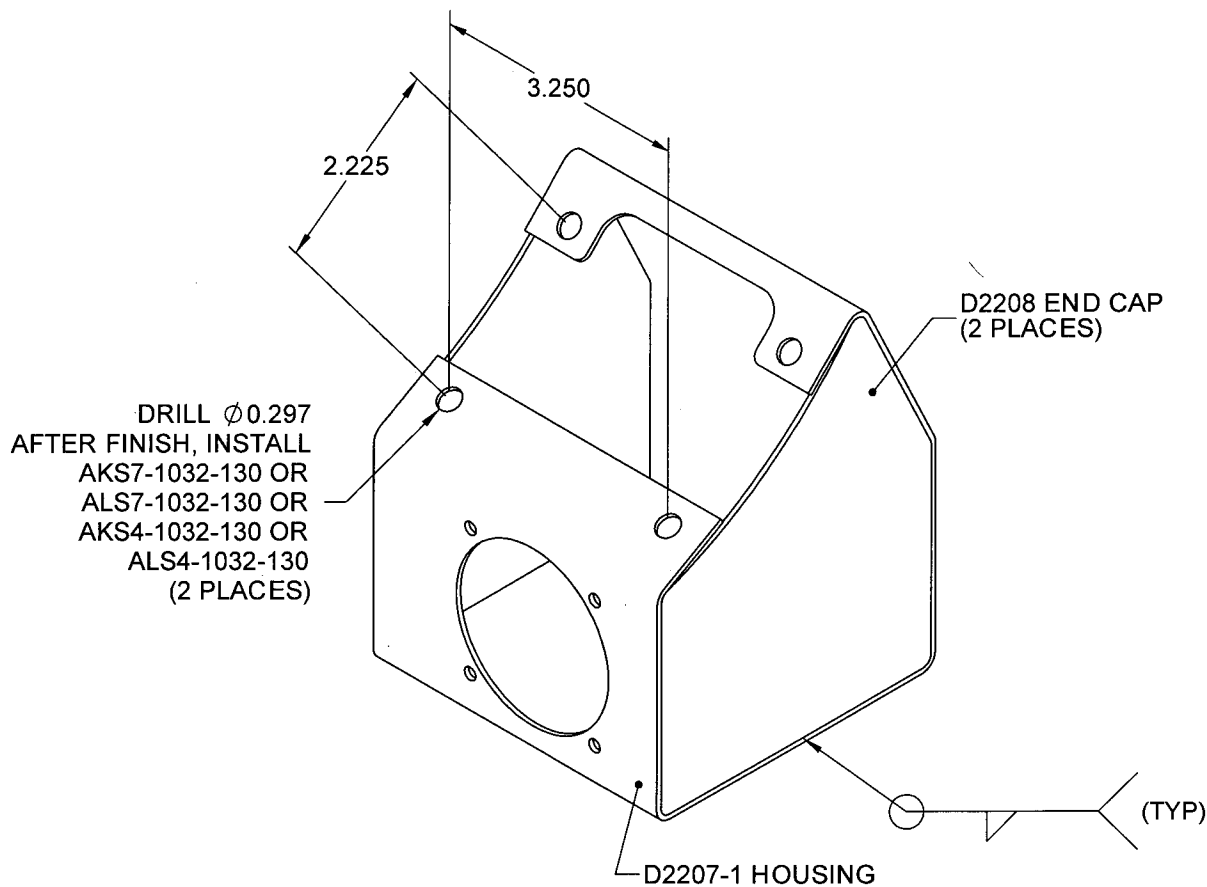
WORK ORDER
NO. 33240



PRELIMINARY ISSUE

07.06.28

DESIGN PH	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED	DRAWING NO. D2207	REV. C SHEET 1 OF 2
DATE 07.06.28		TITLE HOUSING	SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	
C	07.06.28	REDESIGN	



D2207-041 FLAT PATTERN

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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07-06-28

REV. C
SHEET 2 OF 2



Technical drawing of a bent metal profile. The profile is shown in a side view, highlighting its L-shaped geometry with a sloped top section. Key dimensions and features include:

- Top Left Slope:** A sloped section with a thickness of 1.062 and an internal angle of 120°.
- Top Right Slope:** A sloped section with a thickness of 1.036 and an internal angle of 69°.
- Vertical Dimensions:** The total height of the profile is 5.095. The height of the lower vertical leg is 2.910. The height of the upper vertical leg is 2.442.
- Horizontal Dimensions:** The total width of the profile is 4.09. The width of the lower horizontal leg is 2.91.
- Internal Angle:** The angle between the two sloped sections is 155°.
- Radius:** A fillet with a radius of R0.125 is applied at the bottom corner of the lower vertical leg.
- Handwritten Notes:** The number "3.09" is written near the top right corner. The number "3.07.07.03" is written at the bottom right corner.

23 07.07.03

1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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